



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 82593

**\*82593\***

Page 2

April-03-12 10:37:21 AM

Item ID: D3204-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Release Pedal Assembly

Stop

**\*NS2\***

Start Date: 03/04/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

HandFinish

Memo

0.00

Hand Finishing

140

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

**\*140\***

Powdercoat

Memo

0.00

Powder Coating

\*\*\*Cover holes for bushing\*\*\*

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:20 F  
320  
8:50

(5)

(5)

Ng 12-5-1

5X

m/l  
12/05/02

m 117338

# Dart Aerospace Ltd

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# Work Order ID 82593

**\*82593\***

Page 3

April-03-12 10:37:21 AM

Item ID: D3204-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Release Pedal Assembly  
 Start Date: 03/04/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 17/04/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				5	0		12-5-2
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
160		0.00							
<b>*160*</b>	Small Fab					5	0		12/05/03
Small Fab	Memo	0.00							
Small Fab	Install D3204-7 bushing as shown in Dwg D3204								
170	QC5- Inspect part completeness to step on W/O	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

SB  
12/05/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 82593

**\*82593\***

Page 4

April-03-12 10:37:21 AM

Item ID: D3204-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Release Pedal Assembly

Start Date: 03/04/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

Identify as per dwg & Stock Location: *G-A*

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

*5x*

*12/05/03*

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

*12/5/3*

*R1205-3*

# Dart Aerospace Ltd

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**NOTE:** Date & initial all entries



# Picklist Print

April-03-12 10:37:25 AM

Page 1

Work Order ID: 82593

\*82593\*

Parent Item: D3204-041

\*D3204-041\*

Parent Item Name: Release Pedal Assembly

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3204-1 *D3204-1* Tube		Manufactured	No			100	Each	9.0000	1	4			
** EL 12-4-25													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA021		9							
				79294		9							
D3204-11 *D3204-11* Plate		Manufactured	No			100	Each	13.0000	1	4			
** EL 12-4-25													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA021		13							
				57522		13							
D3204-13 *D3204-13* Gusset		Manufactured	No			100	Each	24.0000	2	8			
** EL 12-4-25													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA021		24							
				70315		3							
				73465		21							
D3204-3 *D3204-3* Arm		Manufactured	No			100	Each	18.0000	1	4			
** EL 12-4-25													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA019		18							
				79801		18							

# Dart Aerospace Ltd

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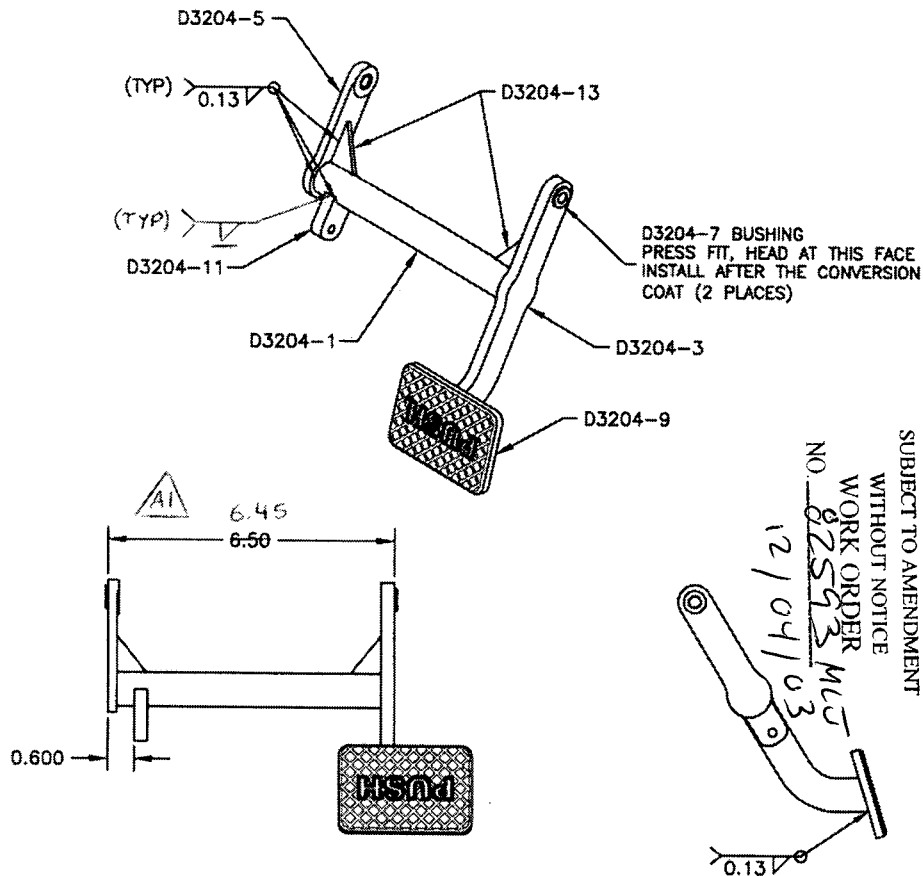
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED  
04.04.30



### D3204-041 RELEASE PEDAL ASSEMBLY

#### NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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**Dart Aerospace Ltd**

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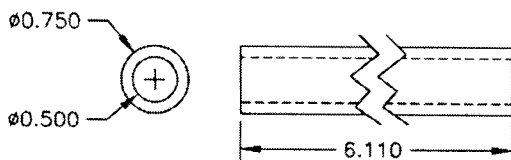
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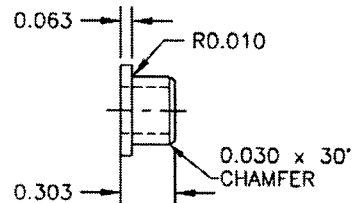


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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

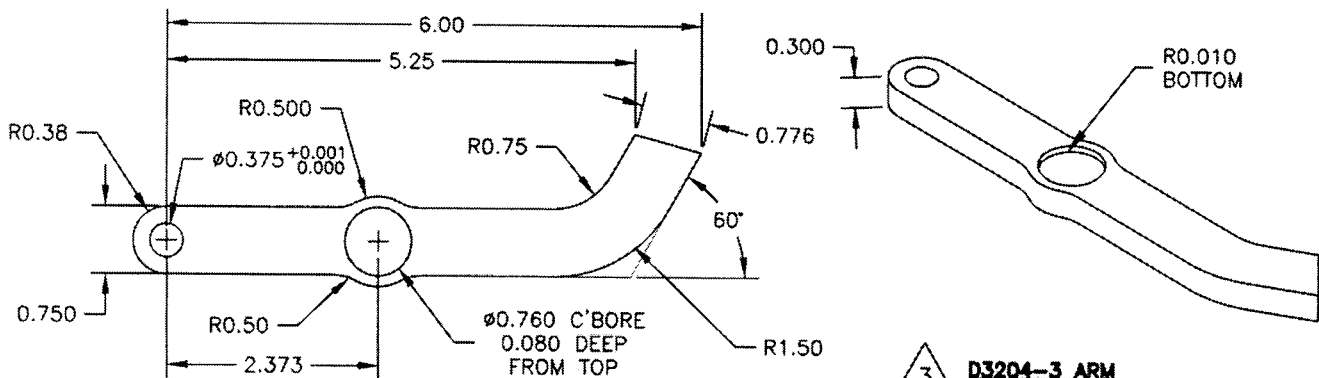
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04.04.05



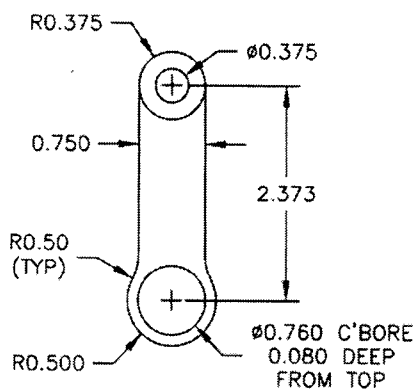
2 D3204-1 TUBE  
SCALE 1:2



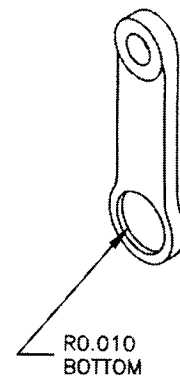
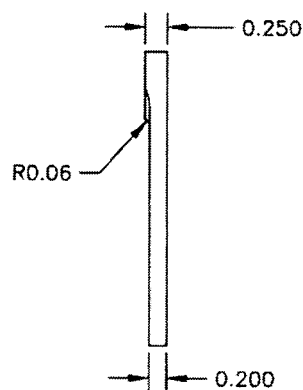
4 D3204-7 BUSHING  
SCALE 1:1



3 D3204-3 ARM  
SCALE 1:2



3 D3204-5 ARM  
SCALE 1:2



02593

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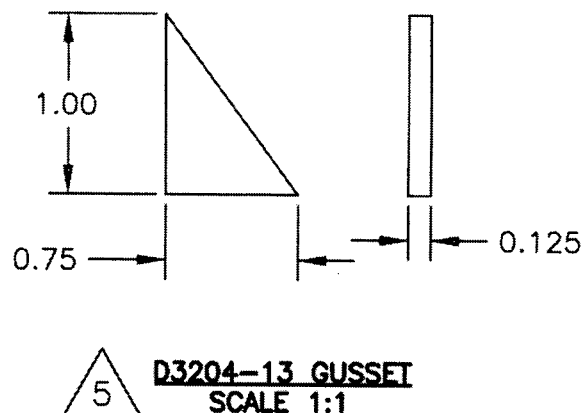
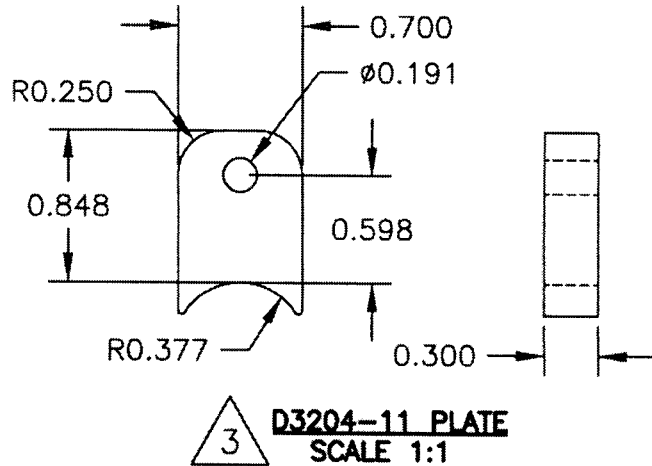
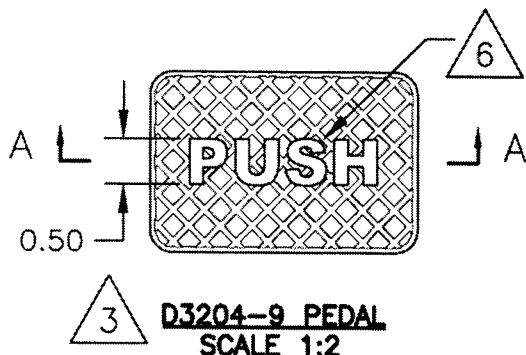
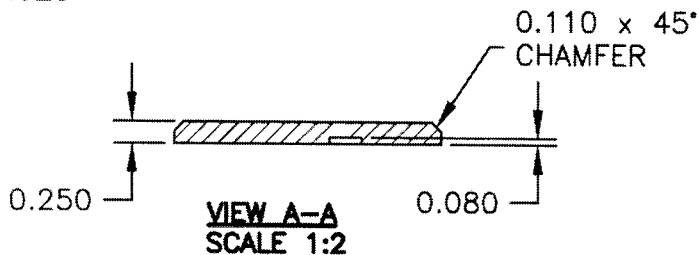
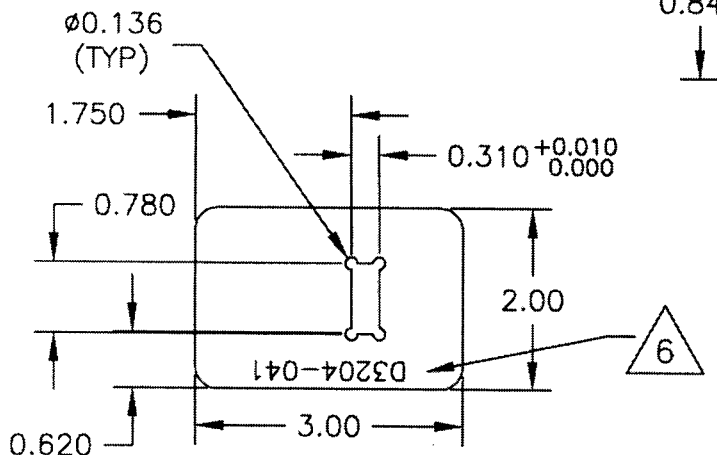
**NOTE:** Date & initial all entries





DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

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04 04 30



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